

Work Order ID 80419

80419

Page 1

February-21-12 9:09:18 AM

Item ID: D3637-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bracket Assembly
 Start Date: 21/02/2012 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 06/03/2012 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/02/21 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3637	Rev B

100

100

Waterjet

FLOW CNC Waterjet

304 086

FLOW WATER JET

Memo

1-Cut as per Dwg D3637 Dwg Rev: B Prog Rev: B 2-
 Deburr if necessary

0.00

0.00

W 12-02-27 (6)

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

M 12-02-27 (6)

120

120

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

5/12/27

(16)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	NC BRAKE	0.00							
130									
Brake NC	Memo	0.00							
Brake NC	Form as per Dwg D3637								
140	Small Fab	0.00							
140									
Small Fab	Memo	0.00							
Small Fab	1- drill holes as per dwg using DT89792-C'Sink as per Dwg D3637 3- Install Nut plate as per Dwg D3637								
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	Memo	0.00							
Quality Control									

SB 12/03/20

SB 12/03/20

SB 12/03/16

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Page 3

Item ID: D3637-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket Assembly

Start Date: 21/02/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 06/03/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: 572400 0.00***160***

Packaging

Memo

0.00

Packaging

11/13/12 (6)

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

12/13/29 MF12-03-28

Dart Aerospace Ltd

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Picklist Print

February-21-12 9:09:21 AM

Page 1

Work Order ID: 80419

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Parent Item: D3637-041

D3637-041

Parent Item Name: Bracket Assembly

Start Date: 21/02/2012

Required Date: 06/03/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC
IPP Rev:B change to REV.B as per dwg 08-02-11 DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS20426AD3-3 *MS20426AD3-3* Rivet		Purchased	No			100	Each	2,775.000	2	12		12/03/12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST316		2775							
					119109	2272							
					19099	503							
M304S14GA *M304S14GA* 304SS sheet .080		Purchased	No			140	sf	103.6000	0.09	0.568421		12 02 27	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT020		103.6							
					117933	7.6							
					119276	96							
MS21059L4 *MS21059L4* Nutplate		Purchased	No			140	Each	53.0000	1	6		12/03/12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST301		53							
					117887	3							
					119623	50							

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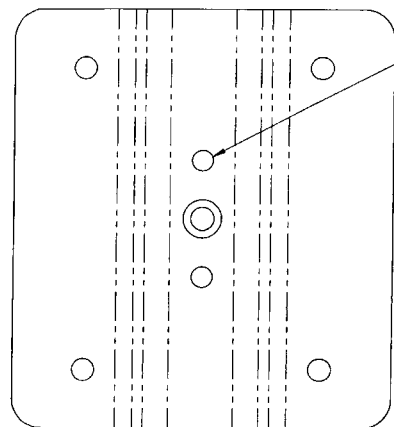
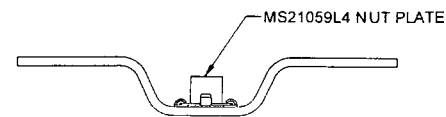
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 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

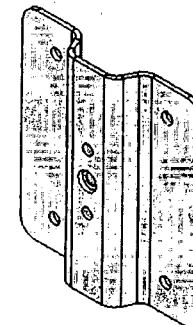
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MS20426AD3-3 RIVET
(2 PLACES)

D3637-1 BRACKET



D3637-041 BRACKET ASSEMBLY
(WAS GENEVA P/N G10602-1)

D3637-041 PARTS:

QTY	P/N	DESCRIPTION
X	D3637-041	BRACKET ASSEMBLY
1	D3637-1	BRACKET
1	MS21059L4	NUTPLATE
2	MS20426AD3-3	RIVET

D3637-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: N/A
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.27 lbs

80419 M.C.J
12/02/21

RELEASED
7-2-05

B	FOR D3637-1, 1 15 WAS 1.30 & "REF" REMOVED FROM ANGLE	LE	07.12.18
A	NEW ISSUE; REPLACES G10608, G10602 & G10609	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	JS		
DRAWN	JS		
CHECKED	JS		
MFG. APPR.	JS		
APPROVED	JS		
DE APPR.	JS		
DATE	07.12.18		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3637 REV. B
SHEET 1 OF 3

TITLE BRACKET SCALE 1:1

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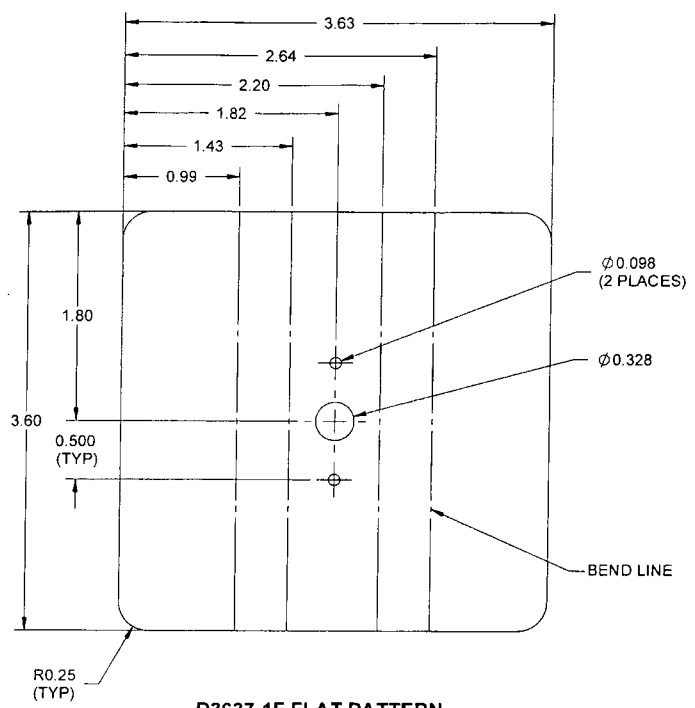
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

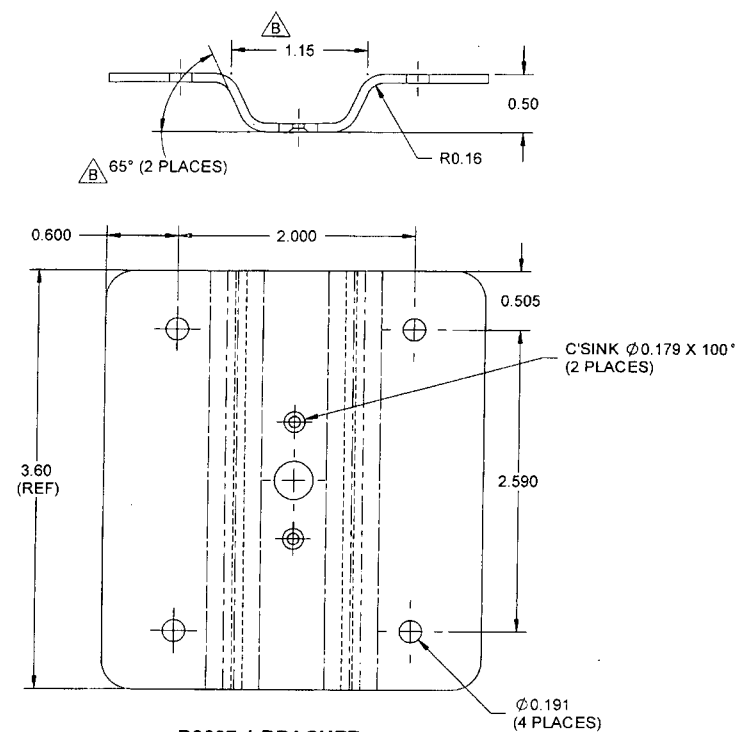
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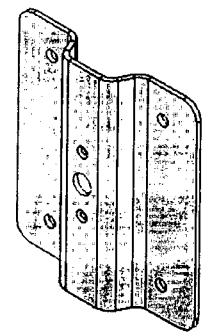
80419



D3637-1F FLAT PATTERN



**D3637-1 BRACKET
(WAS GENEVA P/N G10608-1)**



- D3637-1 NOTES:**
- 1) MATERIAL: AISI 304/316 SS SHEET, 14 GAUGE PER MIL-S-5059 (REF DART SPEC M304S14GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.26 lbs

DESIGN	TS	DART AEROSPACE LTD	
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MFG. APPR.	JS	D3637	SHEET 2 OF 3
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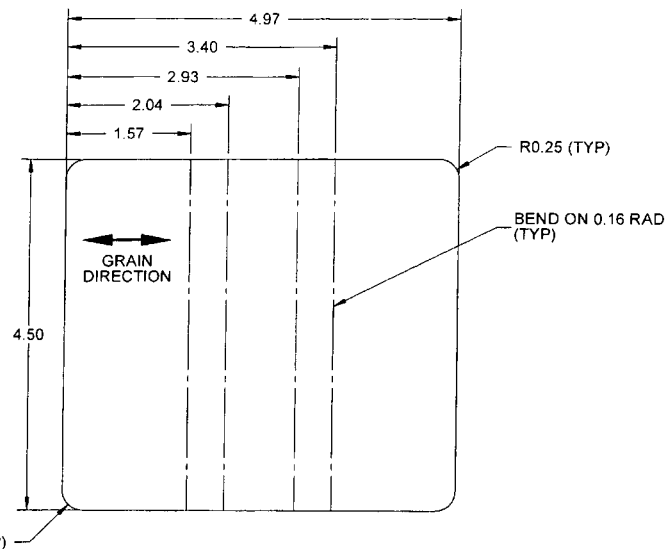
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

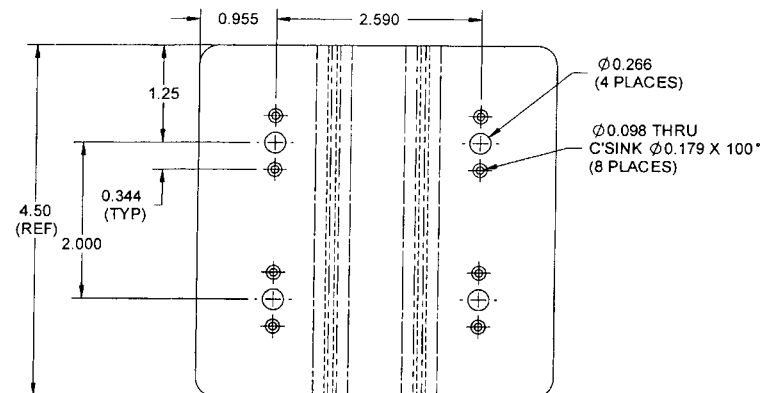
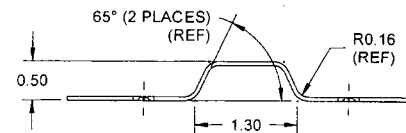
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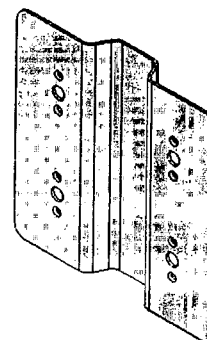
80419



D3637-3F FLAT PATTERN



**D3637-3 BRACKET
(WAS GENEVA P/N G10609-1)**



D3637-3 NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-3" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.32 lbs

DESIGN	TS	DART AEROSPACE LTD	
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MFG. APPR.	Ph	SHEET 3 OF 3	
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